

Work Order ID 50910

July 24, 2009 4:08:37 PM



Page 1

Item ID: D3874-1
Revision ID: A
Item Name: Floor Protector

Accept



Setup Start



Stop



Start Date: 07/27/2009 Start Qty: 6.00
Required Date: 08/31/2009 Req'd Qty: 6.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *mf*
QC:

Date: 09-07-24 Tooling:
Date: SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

M111508

BB 09/07/28 X6

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9453
Dwg Rev: *A*
Folio Rev: *A*

BB 09/07/28 X6 X1

SCRAP PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
05-08-12	W/O header	Added Dwg & Rev to box perman change	PE	09.08.14	-	050812	050812	

Part No: D3874-1 PAR #: N/A Fault Category: Thermal NCR: Yes No DQA: Yes Date: 09.08.14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 09.08.17

NCR: 50910		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/07/28	110	PART NOT CORRECTLY FORMED R.C: Program & inside temp.	JB 09/07/28	SEAL HOLD INCREASE TEMP. 325-334° Replace only 1	JB 09/07/28	JB 09.08.06	JB 09/07/28	JB 090806

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

BB 07/08/05

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 808/08/05

(+6)

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

6
X6 BB 07/08/07

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp
Stamp

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Complete FAI document

6 BB 09/08/07

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

=> 509/08/07

(48) /

170



Packaging

Packaging

Identify as per dwg & Stock Location:

Handwritten signature

0.00

Memo

0.00

9/4/7 6x 50

(6) BB 09/08/07

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Page 4

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Handwritten signature and date 07-26-12

MF 09-08-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 1

July 24, 2009 4:08:37 PM

Work Order ID: 50910

Parent Item: D3874-1RevA

Parent Item Name: Floor Protector

Comments:

Start Date: 07/27/2009

Required Date: 08/31/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	600.0000	26.2800			



Lexan Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

600

111588

600

M111588 BB 09/08/07, (6+1) 7

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	50910
Description: FLOOR PROTECTOR		Part Number:	D3874-1
Inspection Dwg: D3874	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

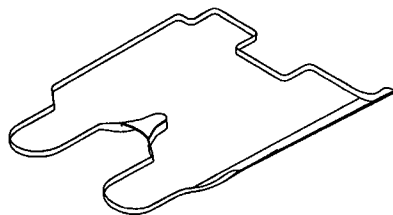
Measured by: BB Date: 09/08/05

TRIMMING SECTION

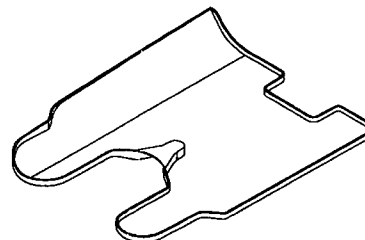
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	.052	✓			
0.065	Min	.081	✓			
.5	Min	.518	✓			

Measured by: BB Date: 09/08/05
Audited by: S Date: 09/08/05
Prototype Approval: A/A Date: A/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

#50910

RELEASED
29/03/05

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3874	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	09.01.29	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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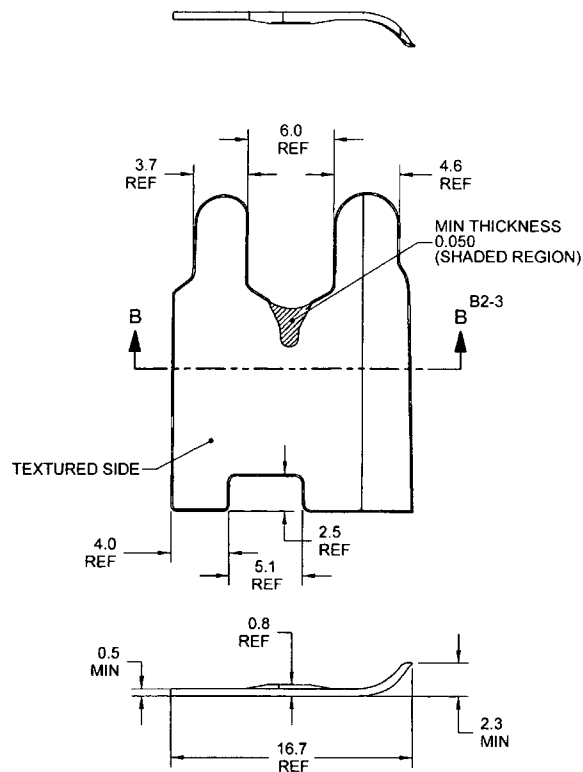
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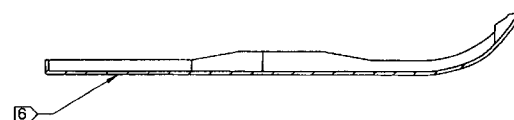
NOTE: Date & initial all entries



D3874-2 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN



SECTION B-B
SCALE 2X

RELEASED
9/15/03

DESIGN	PA	DART AEROSPACE LTD	
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO. D3874	REV. A
MFG. APPR.	PA	SHEET 3 OF 3	
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	FLOOR PROTECTOR	NTS
DATE	09.01.29	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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